

IN THE CLAIMS

Please amend the claims as follows:

1. (Currently Amended) A process for producing a turbine blade or vane having a longitudinal axis, in which process a casting (10, 10', 10''), which is in the basic shape comprising the steps of:

producing the turbine blade or vane, is produced in a casting mold, and then, to complete the turbine blade or vane,;

finishing the turbine blade or vane by fixing the casting (10, 10', 10'') is in a first position;

subjected subjecting the casting in said first position to an automatic material-removing machining process being program-controlled with respect to said first position, characterized in that wherein a leading-edge angle of the turbine blade or vane which is altered in order to optimize the turbine is achieved by changing the machining of

rotating, prior to said material-removing machining process, the casting (10, 10', 10'') around said longitudinal axis from said first position to a second position, and

subjecting said casting in said second position to said automatic material-removing machining process being program-controlled with respect to said first position, while retaining the same casting mold.

2. (Currently Amended) The process as claimed in claim 1, characterized in that further comprising the steps of:

holding the casting (10, 10', 10'') is held in a holder during the machining, and rotating in that the casting (10, 10', 10'') is rotated in the holder for the purpose of changing the machining, with the reference points required for the machining being repositioned.

3. (Currently Amended) The process as claimed in claim 1, ~~characterized in that~~
further comprising the steps of:

holding the casting (10, 10', 10'') ~~is held~~ in a holder during the machining, and
rotating ~~in that~~ the casting (10, 10', 10'') ~~is rotated~~ together with the holder for the
purpose of changing the machining, the correctly calculated distances being used to reach the
desired position.

4. (Currently Amended) The process as claimed in ~~one of claims~~ claim 1 to 3,
~~characterized in that~~ further comprising the steps of:

providing an additional machining stock (14, 14', 14'') ~~is provided~~ on the casting (10,
10', 10'') for the material-removing machining, and

selecting ~~in that~~ the thickness of the additional machining stock (14, 14', 14'') ~~is~~
~~selected~~ to be sufficiently above a minimum value for it to be possible for a turbine blade or
vane which has a leading-edge angle which can be selected freely within a predetermined
range of angles to be produced by machining from the same casting (10, 10', 10'').

5. (Currently Amended) The process as claimed in claim 4, ~~characterized in that~~
wherein the casting (10, 10', 10'') for the turbine blade or vane has a blade or vane platform
[[(11)]] and a main blade or vane part [[(12)]], and the process further comprises the step of:

providing ~~in that~~ the additional machining stock (14', 14'') above the minimum value
~~is provided~~ on the blade or vane platform (11).

6. (Currently Amended) The process as claimed in ~~one of claims~~ claim 4 ~~[[or 5]]~~,
~~characterized in that~~ wherein:

the minimum value for the additional machining stock is approximately 2 mm, and
~~in that~~ the additional machining stock (14', 14'') above the minimum value amounts to
a total of about 5 mm.

IN THE DRAWINGS

The attached sheet of drawings includes changes to Figs. 1-3. This sheet, which includes Figs. 1-3, replaces the original sheet including Figs. 1-3.

Attachment: Replacement Sheet